

Date: Tuesday, 15/08/2006 7:15:56 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 A/B HIGH GEAR SKIDTUBE
Job Number : 28155	
Estimate Number : 10170	
P.O. Number : <i>N/A</i>	Part Number : D206642212
This Issue : 15/08/2006 S.O. No. : <i>N/A</i>	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : N/A
Previous Run : 28154	Material : <i>N/A</i>
Written By : _____	Due Date : 06/09/2006 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : Est Rev/K 05.07.14 ECN 847 & 901; Add Tow Ring and GHW Kit KJ/CP/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP206-642-212 CHG004

KS 06-0830 (1)

2.0	28155A	HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
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Comment: Sub-Component HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

PV61167 (1)

4.0	D206651041	206 A/B GHW Kit
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description Batch
1 D206-651-041 GHW Kit	<i>B27963-</i>
1 D206-642-241(REF)	<i>B28155A</i>

5.0	D2652	Bushing
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description Batch
✓ 16 D2652	Bushing <i>B28252</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 28155

Part Number: D206642212

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2655

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 1 D2655 Tow Ring B27110

7.0

D26652

Saddle, RH, Fwd,Aft, Out



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 2 D2665-2 Saddle B25980

8.0

D26662

Saddle, RH, Fwd,Aft, In



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 2 D2666-2 Saddle B25981 1x - B24850 1x -

9.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 10 D2712 Set Screw B26796

10.0

D2884

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2884 SADDLE SPACER B25982

11.0

D2885

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Saddle Spacer

B23926

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Job Number: 28155

Part Number: D206642212

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 8 AN3-41A

Bolt

M102171 -

13.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 1 AN4-5A

Bolt

M100857 -

14.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 12 AN4-6A

Bolt

M101418 -

15.0

AN57A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 4 AN5-7A

Bolt

M100826 M102140

16.0

AN511A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 4 AN5-11A

Bolt

M102328 -

17.0

AN644A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 2 AN6-44A

Bolt

M100447 -

W/O:		WORK ORDER CHANGES					
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Job Number: 28155

Part Number: D206642212

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD10

Washer M100743 -

19.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

25 AN960JD416

Washer M102339 -

20.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD516

Washer M102328 -

21.0

AN960JD616

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN960JD616

Washer M101124 -

22.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 MS21042L3

Nut (or -3) M101812 -

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 28155

Part Number: D206642212

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 12 MS21042L4 Nut (or -4) M19098

24.0

MS21042L6

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 2 MS21042L6 Nut (or -6) M100181

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-212

Location: 0

PPP Rev: 0

27.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U D611/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Date: Tuesday, 15/08/2006 7:16:43 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
Job Number : 28155A	
Estimate Number : 10163	
P.O. Number : N/A	Part Number : D206642241
This Issue : 15/08/2006 S.O. No. : N/A	Drawing Number : D2650 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : E
Previous Run : 28154A	Material : N/A
Written By : _____	Due Date : 06/09/2006 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:M 04.12.02 Revised procedural steps KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-241 CHG003

KJ 06.07.03 ①

2.0	D2620	Bent 206 Skidtube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2620	Bent Tube 3" OD	B22831

DP 6-8-31

3.0	D32861	Doubler
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3286-1	Doubler	B229594

BE 06-10-05

4.0	D2647	Cap
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2647	Fwd Cap	B24842

BE 6-9-11

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 28155A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod *M101655/M101010 BE 6-9-11*

4-Grind weld flush to cap on top surface only. *Pm '06-9-20 ①*

5-Cut Aft end as per dwg 2650 from front of tube and Deburr *Pm '06-9-20 ①*

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650 *BE 06-10-05 ①*

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025. *BE 06-10-05 ①*

8-Drill pilot holes using Dt 8167. *BE 06-10-05 ①*

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support. *BE 06-10-05 ①*

10- Drill D3286-1 doubler rivet holes in tube using #40 drill, spot drilling doubler at the same time. *BE 06-10-05 ①*

11-Working from the center out, drill #30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. *BE 06-10-05 ①*

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650 *BE 06-10-05 ①*

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder *BE 06-10-05 ①*

14-Remove indexing edge using DT8741 as per Dwg D2650 *BE 06-10-11*

15-C'sink GHW rivet holes as per Dwg D2650 *BE 06-10-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 28155A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Joe-10-11-10

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to $\varnothing 0.3125$ " as per Dwg D2650

BE 06-10-11

2-Drill pilot holes using DT8028-3, then open to $\varnothing 0.297$ " as per Dwg D2650. Open Aft cap hole #6.

BE 06-10-17

3-Deburr tube and blow out chips from inside the tube

BE 06-10-11

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.H 06/10/12

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

pm '06-10-17

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)

pm '06-10-17

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

pm '06-10-17

3-Deburr and blow out all chips from inside the tube

pm '06-10-17

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

BE 06-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Date: Tuesday, 15/08/2006 7:16:44 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 28155A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet M101692 BE 06-10-19

13.0

D26543

206 I-Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2654-3 Web B29008 Pmc 06-10-20 (1)

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required BE 06-10-19

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 06-10-20 Time: 10:30

Finish Date: 06-10-23 Time: 7:30 Am

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M102101 Pmc 06-10-20 (1)

Sikaflex expire date: 07-02-01

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-10-23 (1)

16.0

D2649

Crossbolt Spacer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2649 Crossbolt spacer B28250 BE 06-10-23 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 28155A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3286-3

Spacer

BE 24711 BE 06-10-26

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

M101010

BE 06-10-23

(1)

2-Grind welds flush as per Dwg D2650.

BE 06-10-26

(1)

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod

NONE USED

BE 06-10-26

(1)

4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

Pm' 06-10-27

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets

M101938

Pm' 06-10-27

(2)

20.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets

M19099

Pm' 06-10-27

(2)

W/O:		WORK ORDER CHANGES					
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Job Number: 28155A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041 Nut Plate

B24203 Pm 06-10-27 (1)

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pm 06-10-27 (1)

Install D2680-041 Nut Plate as per Dwg D2650

23.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and Counterbore work to Current Step. Inspect for foreign objects as per QSI 024

06-10-27 (1) 06/10/300 (1)

24.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

06-11-01 (1)

25.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 11 02 (1)

26.0

D26483

Wearpad



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2648-3 Wearpad

B27169

27.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-13 Wearshoe

B27739

06-11-02 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 28155A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-21

Wearshoe

B 27075

29.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-33

Wearshoe

B 28179

30.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

B 29201

31.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 ALS4-1032-130 Inserts

M 18990

or (see QSI 017)

32.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 AN960JD10L

Washer

M 100233

a.m. 06/11/02 61

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:16:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 28155A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

MS27039108

Screw



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number Description Batch
44 MS27039-1-08 Screw M102404

34.0

D26511

Plug



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch
18 D2651-1 Plugs B 28251

35.0

D26513

O-Ring



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch
18 D2651-3 O-Rings 15X B 25866 3X D28401

36.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 MS27039-4-06 Screw M1151 M6874

37.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 AN960JD416 Washer M6874 M1151 Q.M. 06/11/02 Q

38.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:16:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 28155A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291 M 102107

Sikaflex expire date: 02/02

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

39.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect for foreign objects as per QSI 024

M 06/11/02

40.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B28041

41.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw M 102404

42.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer M 100233

M 06/11/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:16:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 28155A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M102107

Sikaflex expire date: 02/07

a.m. 06/11/02 @

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch: M102098

yl 06/11/06

44.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

M 06/11/08 @

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206664241 IF APPLICABLE

Location: _____

PPP Rev: _____

N/A Pcg/yl.s

46.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

①
D 06/11/10

Job Completion



U 06/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 38

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number A206G42241 / B28155A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	3G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/23 Qualifier Dan D. Sural